

Application No.: 09/942,250

Docket No.: 60680-1187

**AMENDMENTS TO THE CLAIMS**

1. (Currently Amended) A method for manufacturing an insert for a combustion head gasket ~~includes~~ comprising the steps of: (a) providing a mold apparatus having an upper mold section and a lower mold section, said lower section defining a cavity adapted to receive a blank metal substrate; (b) placing said blank metal substrate into said cavity; (c) closing said upper mold section against said blank metal substrate to hold said blank metal substrate in place under a first applied force; (d) applying a second force greater than the first force to shape bend at least one finger extending from said blank metal substrate; (e) supplying elastomeric material to selected predetermined portions of said blank metal substrate; and (f) curing the elastomeric material.

2. (Original) The method of claim 1 wherein said insert is adapted to seal an engine oil flow aperture of said combustion head gasket, said blank metal substrate including a body portion adapted for registration with the oil flow aperture.

3. (Currently Amended) The method of claim ~~2~~ 1 wherein said insert comprises a ~~metallic body and includes~~ an elastomeric sealing bead bonded to said ~~body~~ blank metal substrate, wherein said ~~body~~ blank metal substrate is plastically deformed via said application of said second force to shape said ~~insert~~ blank metal substrate.

4. (Currently Amended) The method of claim 3 wherein said insert is manufactured in a single mold process that includes said shaping of said ~~insert body~~ blank metal substrate and said molding of said bead.

5. (Currently Amended) The method of claim 4 wherein said elastomeric sealing bead bonded to said ~~body~~ blank metal substrate comprises a sealing portion disposed about a peripheral edge of said ~~body portion~~ blank metal substrate of said insert ~~body~~.

6. (Currently Amended) The method of claim 5 wherein said step of supplying includes supplying said sealing bead ~~body portion of said insert defines to form~~ a closed loop, and wherein said insert further comprises radially extending arms provided for attachment of said insert to the a combustion head gasket.

7. (Currently Amended) The method of claim 6 wherein said second force forms at

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least one ~~of said arms comprises an~~ offset elbow.

8. (Original) The method of claim 7 wherein said elbow provides a connection between said arm and a shoulder portion of said insert, wherein said shoulder portion is contiguous with said peripheral edge of said closed loop portion of said insert.

9. (Original) The method of claim 8 wherein said closed loop is generally non-circular.

10. (Original) The method of claim 9 wherein said mold apparatus comprises die inserts for forming said insert.

11. (Previously Presented) A method for manufacturing a combustion head gasket comprising the steps of:

- (a) providing a mold apparatus having an upper mold section and a lower mold section, said lower mold section defining a cavity for selectively receiving a blank metal substrate;
- (b) placing said blank metal substrate into said cavity;
- (c) closing said upper mold section against said blank metal substrate to hold said blank metal substrate in place under a first applied force;
- (d) applying a second force greater than said first force to shape said blank metal substrate, wherein said blank metal substrate is shaped by bending fingers that extend from said blank metal substrate;
- (e) supplying an elastomeric material to selected predetermined portions of said blank metal substrate; and
- (g) inserting said fingers into apertures formed within the gasket.

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12. (Previously Presented) A method for manufacturing an insert for a combustion head gasket comprising the steps of:

- (a) providing a mold apparatus having an upper mold section and a lower mold section, said lower mold section defining a cavity for selectively receiving a blank metal substrate;
- (b) placing said blank metal substrate into said cavity;
- (c) closing said upper mold section against said blank metal substrate to hold said blank metal substrate in place under a first applied force;
- (d) applying a second force greater than said first force to shape said blank metal substrate; and
- (e) supplying an elastomeric material to selected predetermined portions of said blank metal substrate, wherein said predetermined portions of said blank metal substrate are not shaped by said second force.

13 (New) The method of claim 1, wherein said step of supplying elastomeric material to selected predetermined portions of said blank metal substrate include supplying elastomeric material to opposing outer surfaces of said blank metal substrate.